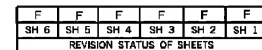


⑩ CHECK FUNCTIONAL CONDITION WITH GAGE 12923171.

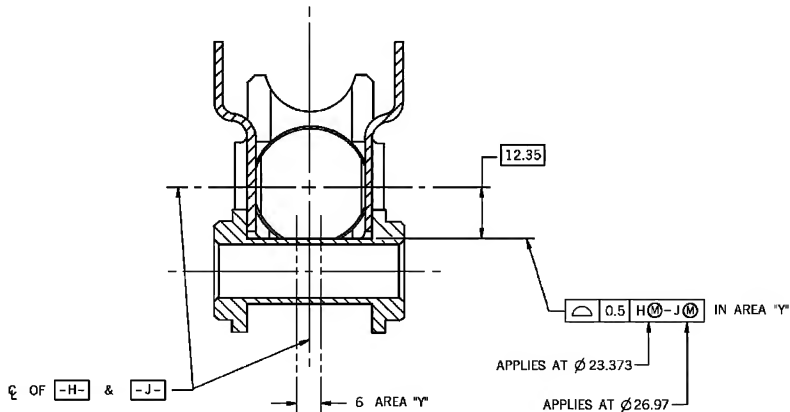


SCALE	1 / 1	UNIT WT.	SHEET	1 OF 6
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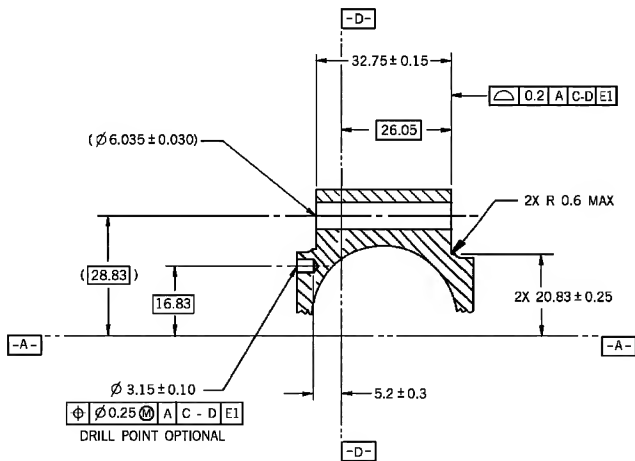
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[illegible]

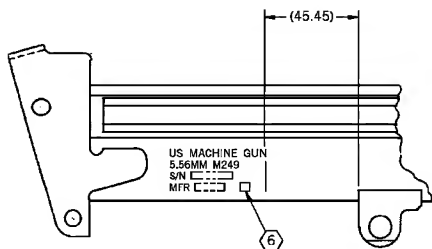
REVISIONS					
ZONE	LTR	DESCRIPTION	DATE	BY	APPROVED
B	NOR	G1S2002 R1	911213	921215	<i>DLW</i>
C	NOR	G3S4602 / 940112 (ECP G3S4601 / 940216) (ECP G4S2012 / 940406)		950614	<i>DLW</i>
D	NOR	G5S2009 / 950407 (ECP G6S2021 / 960904) (ECP G6S4183 / 960904)		970516	<i>DLW</i>
E	NOR	L7S4181 / 881088 (ECP L7S4182 / 971029)		980630	<i>DLW</i>
F	NOR	L062034 / 001031		010228	<i>DTC</i>



SECTION E-E
SCALE 2/1



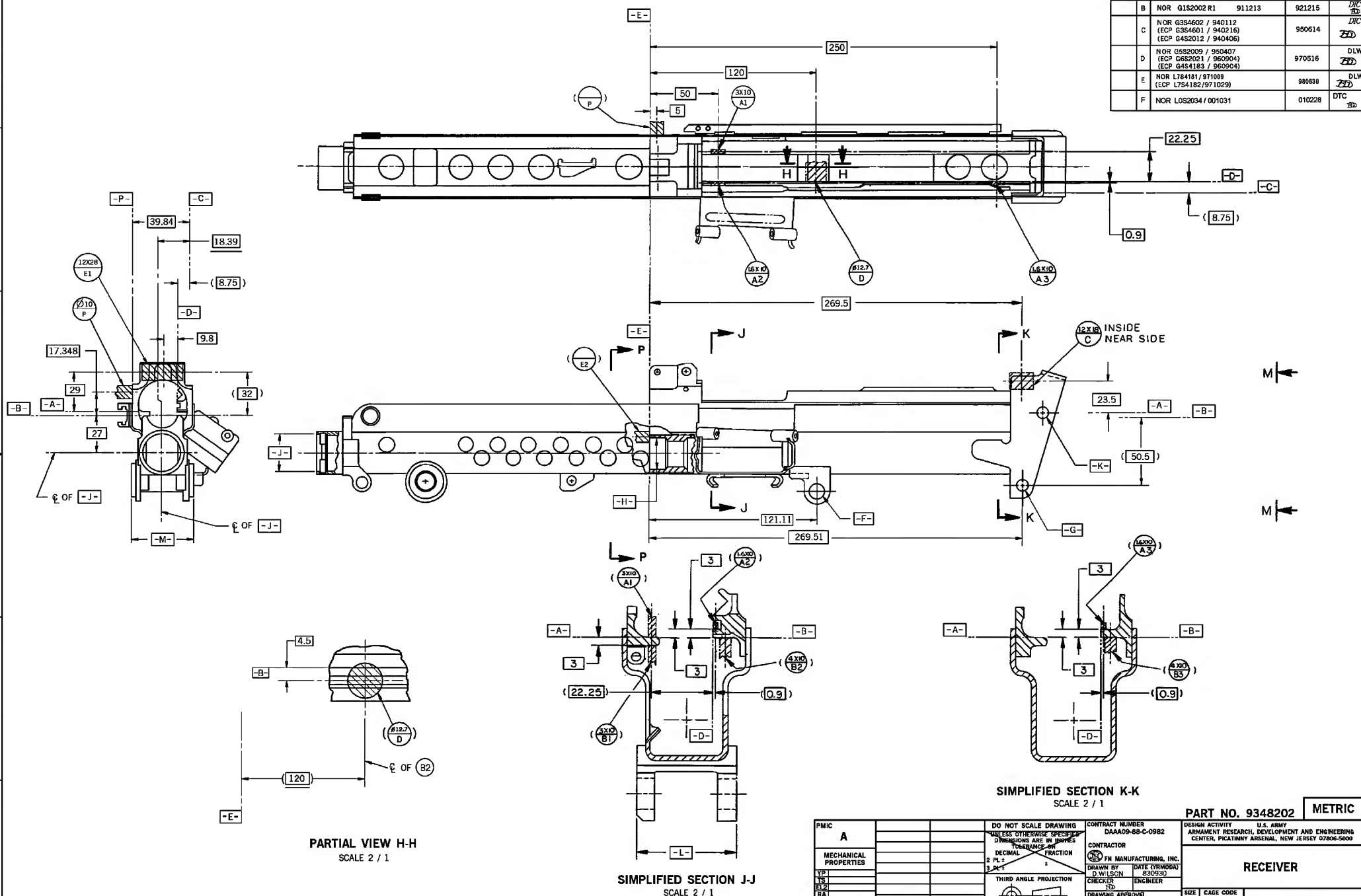
PARTIAL SECTION L-L
SCALE 2/1



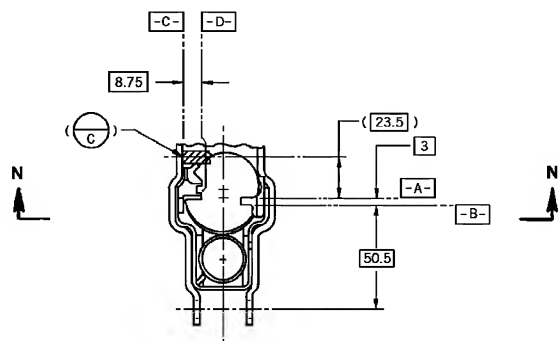
PARTIAL VIEW F-F
WEAPON MARKING LOCATION

PMIC A		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMAL FRACTION 2 PL. 1 3 PL. 1		CONTRACT NUMBER DAAA09-88-C-0982		DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER, PICATINNY ARSENAL, NEW JERSEY 07806-5000	
MECHANICAL PROPERTIES		THIRD ANGLE PROJECTION		CONTRACTOR FN MANUFACTURING, INC.		RECEIVER	
YP LTS ELP BA BH RH		9348201 M249 M.G. NEXT ASSY USED ON APPLICATION		DRAWN BY D. WILSON CHECKER ENGINEER		SIZE F 19200	
		MAYL ENG.		DESIGN APPROVAL <i>[Signature]</i>		CAGE CODE 9348202	
				SCALE 1/1		SHEET 4 OF 6	

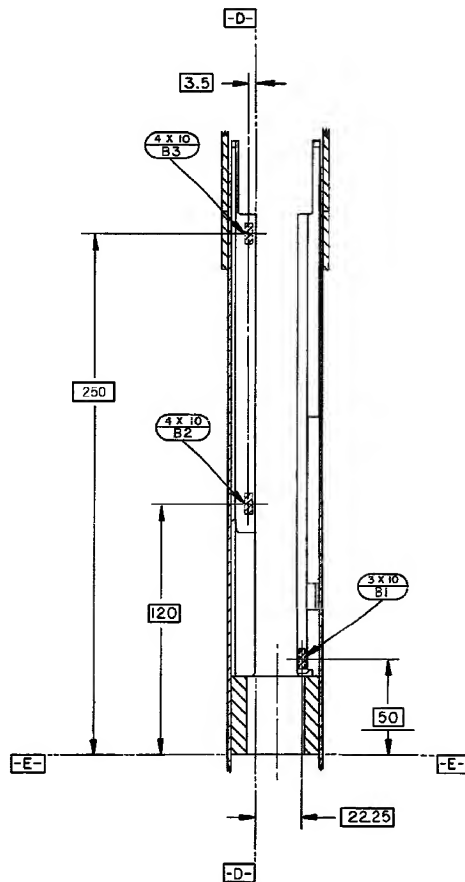
REVISIONS				
ZONE	LTD	DESCRIPTION	DATE (YY MM DD)	APPROVER
B	NOR	G1S2002 R1 911213	921215	DTC <i>DLW</i>
C	NOR	G3S4602 / 940112 (ECP G3S4601 / 940216) (ECP G4S2012 / 940406)	950614	DTC <i>DLW</i>
D	NOR	G5S2009 / 950407 (ECP G6S2021 / 960904) (ECP G4S4183 / 960904)	970516	DLW <i>DLW</i>
E	NOR	L3S4181 / 971008 (ECP L7S4182 / 971029)	980838	DLW <i>DLW</i>
F	NOR	L0S2034 / 001031	010228	DTC <i>DLW</i>



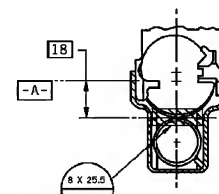
REVISIONS					
ZONE	LTR	DESCRIPTION	DATE (MM-DD-YY)	APPROVED	
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C	NOR	G3S4602 / 940112 (ECP G3S4601 / 940215) (ECP G4S2012 / 940406)		950614	DIC SD
D	NOR	G5S2009 / 950407 (ECP G6S2021 / 950904) (ECP G4S4183 / 950904)		970516	DLW SD
E	NOR	L7S4181 / 971009 (ECP L7S4182 / 971029)		980630	DLW SD
F	NOR	L0S2034 / 001031		010228	DTC SD



PARTIAL VIEW M - M



SIMPLIFIED SECTION N - N



SIMPLIFIED SECTION P-P

PMIC A		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES 2 PL = DECIMAL FRACTION 3 PL = THIRD ANGLE PROJECTION		CONTRACT NUMBER DAAA09-88-C-0982 CONTRACTOR FM MANUFACTURING, INC. DESIGNED BY DATE (YR/MO/DA) D. WILSON 830930 CHECKER ENGINEER		PART NO. 9348202 RECEIVER U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER, PICATINNY ARSENAL, NEW JERSEY 07806-5000	
MECHANICAL PROPERTIES		Y.P. T.S. R.E. R.A. B.H. R.H.		9348201 M249 M.G. NEXT ASSY USED ON APPLICATION		SIZE CAGE CODE F 19200 9348202	
		MATERIAL		DESIGN APPROVAL [Signature]		SCALE 1/1 UNIT WT. SHEET 6 OF 6	

NOTICE OF REVISION (NOR)

This revision described below has been authorized for the document listed.

1. DATE
(YYMMDD)
000731

Form Approved
OMB NO. 0704-0188

Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information including suggestions for reducing this burden to Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302 and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188) Washington DC 20503.

PLEASE DO NOT RETURN YOUR COMPLETED TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT/PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.

2. PROCURING
ACTIVITY NO.
L0S2034

3. DODACC

4. ORIGINATOR

a. TYPED NAME (First, Middle Initial, Last)

b. ADDRESS (Street, City, State, Zip Code)

AMSTA-AR-CCL-A

5. CAGE CODE
19200

6. NOR NO.

L0S2034 -
F9348202

Brian Donovan

ARDEC

Picatinny Arsenal, NJ 07806-5000

7. CAGE CODE
19200

8. DOCUMENT NO.
F 9348202

9. TITLE OF DOCUMENT

RECEIVER

10. REVISION LETTER
a. CURRENT
b. NEW

11. ECP NO.
00SAW-002

12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES

MACHINE GUN, 5.56MM; M249

NOR SH. 1
OF 1

13. DESCRIPTION OF CHANGE:

CHANGE: ON SHEET 1 IN NOTE 3:

FROM:

"AWS 2.4-86"

TO:

"AWS A2.4-86"

UPDATE SHEETS 2-6 OF 6 TO THE NEXT REVISION LEVEL TO MAINTAIN CONTINUITY.

11. THIS SECTION FOR GOVERNMENT USE ONLY

a. (X) one

(1) Existing document supplemented by the NOR may be used in manufacturing.

(2) Revised document must be received before manufacturer may incorporate this change.

(3) Custodian of master document shall make above revision and furnish revised document.

b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT

c. TYPED NAME (First, Middle Initial, Last)

TACOM-AR-ELLY, FWS1A-AH-CCL-F

d. TITLE

e. SIGNATURE

f. DATE SIGNED

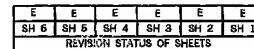
Chief, CACAO FWS & FWS SPI Team

15.a. ACTIVITY ACCOMPLISHING REVISION


b. REVISION COMPLETED (SIGNATURE)

c. DATE SIGNED
(YYMMDD)

⑩ CHECK FUNCTIONAL CONDITION WITH GAGE 12923171 .



RECEIVER			
SIZE	CAGE CODE		
F	19200	9348202	
SALE	1 / 1	UNIT WT.	SHEET 1 OF 6

PNIC		A		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE - 1/16"	
MECHANICAL PROPERTIES				DECIMAL FRACTION	
TH				2 PLT ±	
TC				3 PLT ±	
ED				THIRD ANGLE PROJECTION	
RA		9348201	M249 M.Q.		
BH		NEXT ASSY	USED ON	MATL. ENG.	
RH		APPLICATION			

1

ENPN

1.

DRAWING SIZE F

8

7

6

5

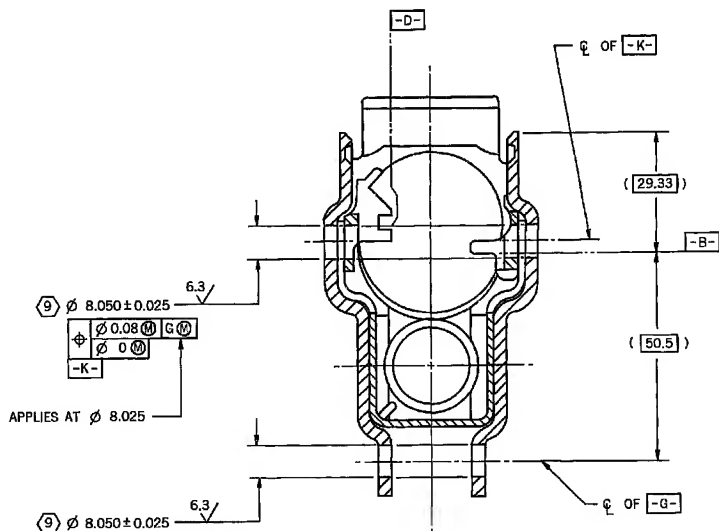
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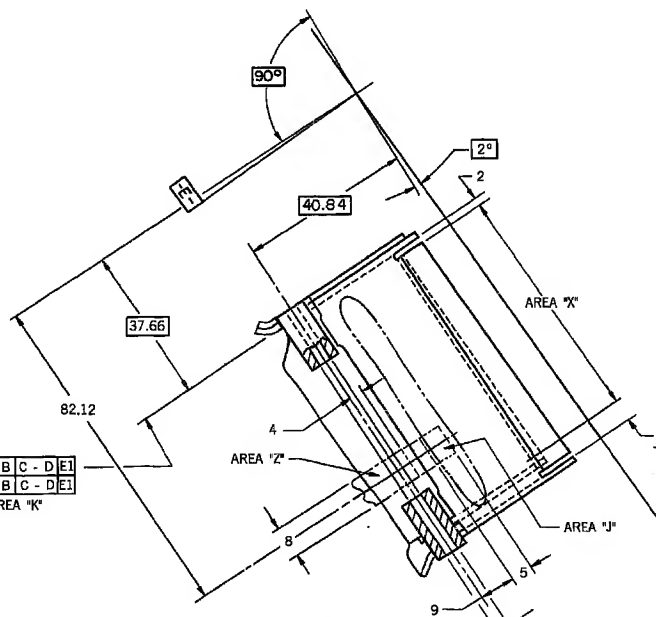
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1

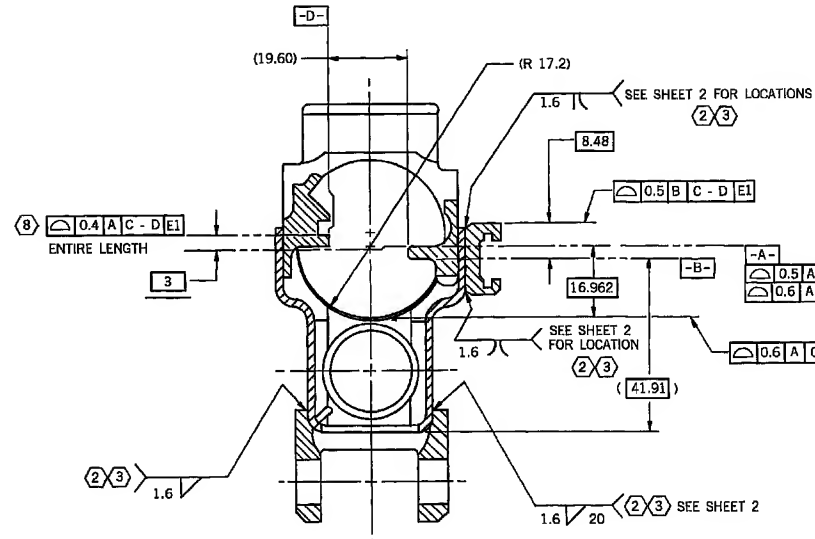
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B	NOR	Q182002 RI 911213	921215	DIC SD
C	NOR	G384602 / 940112 (ECP G384601 / 940216) (ECP G482012 / 940406)	950614	DIC SD
D	NOR	G582009 / 950407 (ECP G582021 / 960904) (ECP G484183 / 960904)	970516	DLW SD
E	NOR	L784181 / 971008 (ECP L784182 / 971029)	980630	DLW SD



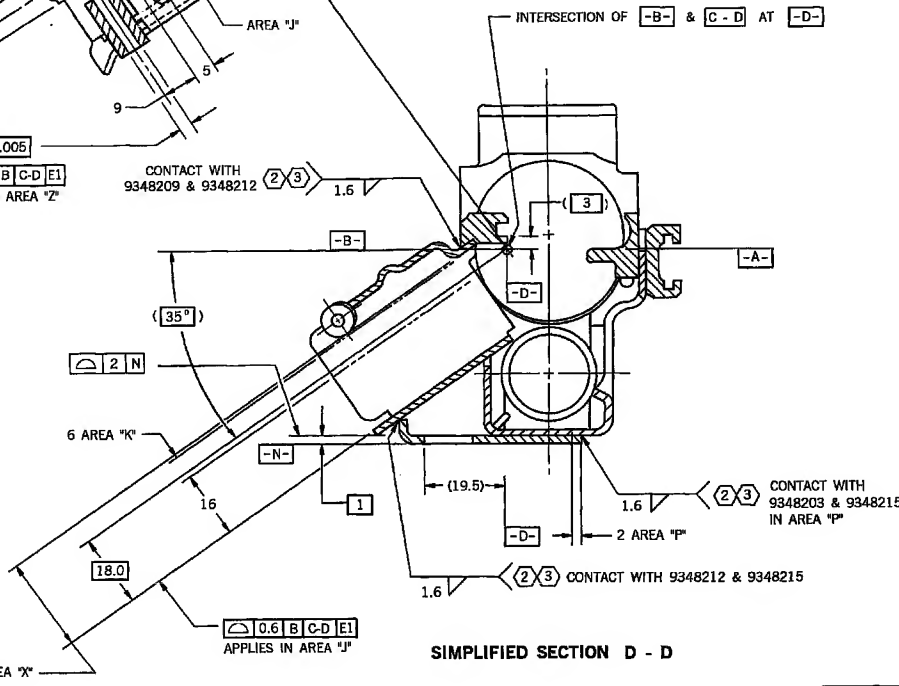
SIMPLIFIED SECTION B - B



CONTACT WITH 9348209 & 9348212
APPLIES IN AREA "Z"



SIMPLIFIED SECTION C - C



SIMPLIFIED SECTION D - D

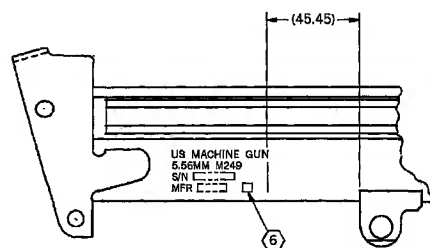
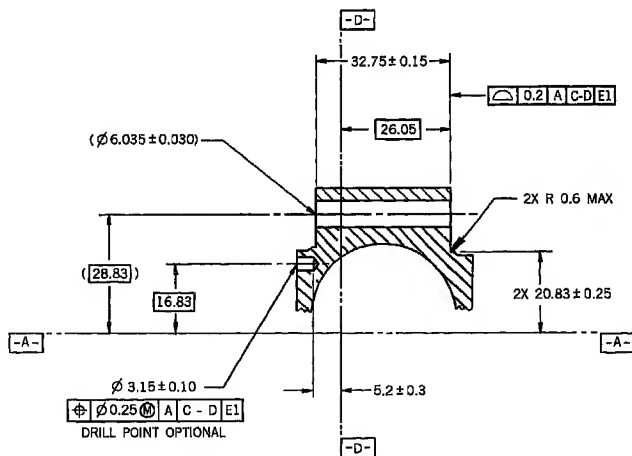
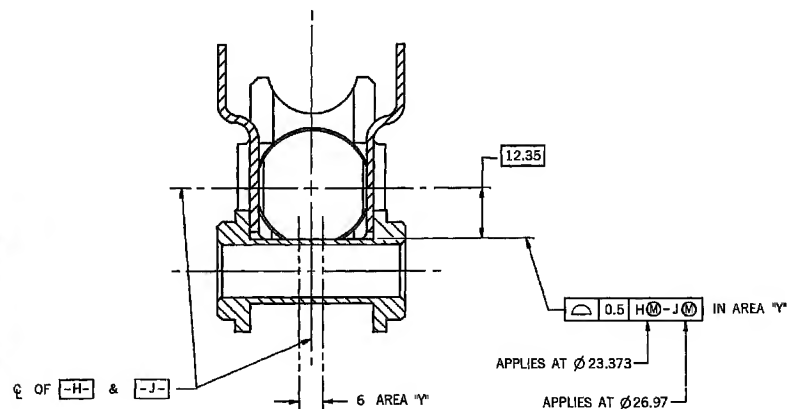
PMIC	A
MECHANICAL PROPERTIES	
Y.P.	
T.S.	
EL.	
RA	
BH	9348201 M249 M.S.
RH	NEXT ASSY USED ON
	APPLICATION

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
THOUSANDS OF
DECIMAL FRACTION
2 PL.
3 PL.
THIRD ANGLE PROJECTION

CONTRACT NUMBER
DAA09-88-C-0982
CONTRACTOR
PM MANUFACTURING, INC.
DRAWN BY
D. WILSON
CHECKED
ENGINEER
DESIGN APPROVAL
DATE (Y/M/D)
8/30/90

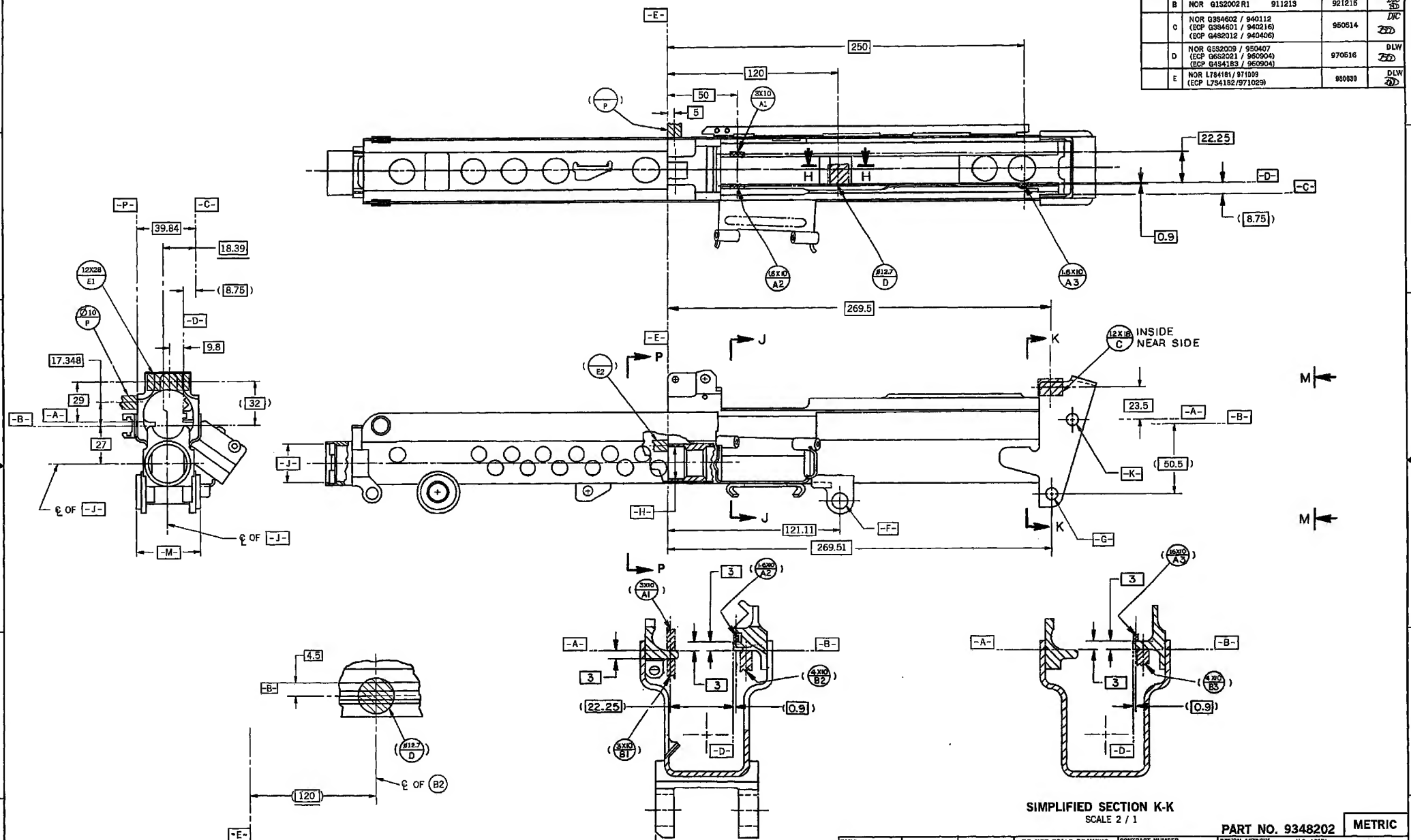
PART NO. 9348202		METRIC
DESIGN ACTIVITY		U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER, PICOCAVITY ARSENAL, NEW JERSEY 07806-5003
RECEIVER		
SIZE	CAGE CODE	9348202
F	19200	
SCALE	2 / 1	UNIT WT.
PPHM		SHEET 3 OF 6

ZONE		DESCRIPTION		DATE (MM-DD-YY)	APPROVED
B	NOR	G182002R1	911218	921215	DIC
C	NOR	G384602 / 940112 (ECP G384601 / 940216) (ECP G482012 / 940406)		950614	DIC
D	NOR	G582009 / 950407 (ECP G582011 / 950504) (ECP G684183 / 950904)		970616	DLW
E	NOR	L784181 / 981008 (ECP L784182 / 971029)		980630	DLW



PMIC		DO NOT SCALE DRAWING		CONTRACT NUMBER		DESIGN ACTIVITY	
A		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:		DAAA09-88-C-0982		U.S. ARMY	
MECHANICAL PROPERTIES		DECIMAL FRACTION		CONTRACTOR		ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER, PICTANTY ARSENAL, NEW JERSEY 07806-8000	
VP		2 PL+ 3 PL+		FH MANUFACTURING, INC.		RECEIVER	
YS		THIRD ANGLE PROJECTION		DRAWN BY DATE (MM-DD-YY)		SIZE CASE CODE	
BA		WATE ENL.		D. WILSON 830930		F 19200	
BH		NEXT ASSY USED ON		CHECKER		9348202	
RH		APPLICATION		DESIGN APPROVAL		SCALE 1/1 UNIT W.T.	
				DATE (MM-DD-YY)		SHEET 4 OF 6	

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (ORIGINAL)	APPROVED
	B	NOR GIS2002 R1	911219	921215
				DIC
	C	NOR G3S4602 / 940112 (ECP G3S4601 / 940216) (ECP G4S2012 / 940406)		950614
				DIC
	D	NOR G5S2029 / 950407 (ECP G6S2021 / 960904) (ECP G4S4183 / 960904)		970516
				DLW
	E	NOR L7S4181 / 971009 (ECP L7S4182 / 971029)		980830
				DLW



PARTIAL VIEW H-H
SCALE 2 / 1

SIMPLIFIED SECTION J-J
SCALE 2 / 1

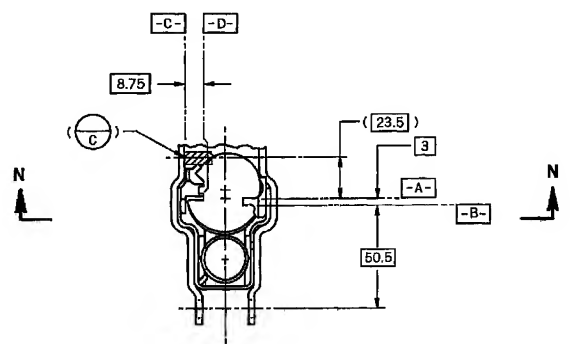
SIMPLIFIED SECTION K-K
SCALE 2 / 1

PMIC		DO NOT SCALE DRAWING		CONTRACT NUMBER		PART NO. 9348202		METRIC	
A		UNLESS OTHERWISE SPECIFIED		DAAA08-BB-C-0882		RECEIVER			
MECHANICAL PROPERTIES		DIMENSIONS ARE IN INCHES		CONTRACTOR		U.S. ARMY			
YIP		TOLERANCE		PM MANUFACTURING, INC.		ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING			
YTS		DECIMAL		D. WILSON		CENTER, PICATINNY ARSENAL, NEW JERSEY 07808-5000			
YLS		2 PL.		DATE (Y/M/D)					
YRA		3 DEC.		830930					
YBH		THIRD ANGLE PROJECTION		CHECKED					
YRH		9348201		DRAWING APPROVAL					
		NEXT ASSY USED ON		DESIGN APPROVAL					
		APPLICATION		SCALE 1 / 1					
				UNIT WT.					
				SHEET 5 OF 6					

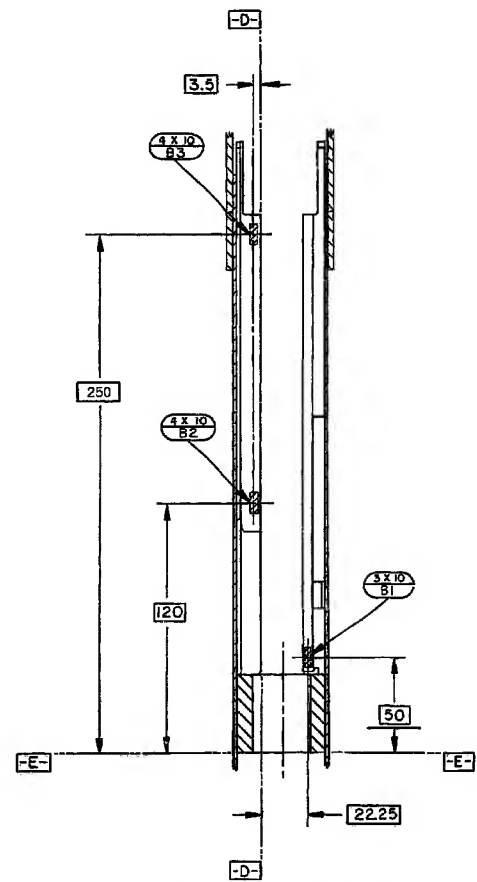
DRAWING SIZE F

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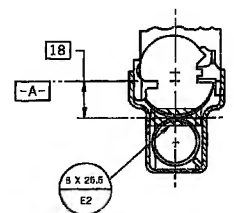
REVISIONS					
ZONE	LTR	DESCRIPTION	DATE (YR-MO-DY)	APPROVED	
	B	NOR G152002 R1	911213	921215	DLW 20
	C	NOR G384602 / 940112 (ECP G384601 / 940216) (ECP G452012 / 940406)		950614	DLW 20
	D	NOR G582009 / 950407 (ECP G652021 / 960904) (ECP G454183 / 960904)		970516	DLW 20
	E	NOR L784181 / 971009 (ECP L784182 / 971029)		980630	DLW 20



PARTIAL VIEW M - M



SIMPLIFIED SECTION N - N



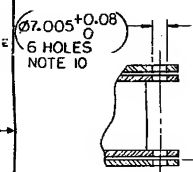
SIMPLIFIED SECTION P-P

PMIC		DO NOT SCALE DRAWING		CONTRACT NUMBER		PART NO. 9348202		METRIC	
A		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE		DAAA09-88-C-0882		DESIGN ACTIVITY		U.S. ARMY	
MECHANICAL		DECIMAL FRACTION		CONTRACTOR		ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING		CENTER, PHOENIX ARSENAL, NEW JERSEY 07068-5000	
PROPERTIES		2 PL ± 3 PL ±		PH MANUFACTURING, INC.		RECEIVER			
YIP		THIRD ANGLE PROJECTION		DRAWING BY DATE (YR-MO-DY)		SIZE		CAGE CODE	
YES				D. WILSON 830930		F 19200		9348202	
ECP				CHECKED ENGINEER		SCALE		UNIT WT.	
RA				DESIGN APPROVAL		1 / 1		SHEET 6 OF 6	
BH		9348201 M249 M.G.		MAYL. ENG.		FPH			
RH		NEXT ASSY USED ON		APPLICATION					

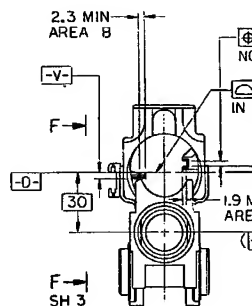
- NOTES:-

- 1- SPEC MIL-W-13855 AND ANSI Y14.5M-82 APPLY.
- 2- UNLESS OTHERWISE SPECIFIED, WELDING SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF MIL-STD-1261 CLASS II, USING FILLER METAL CONFORMING TO SPEC MIL-R-5031, CLASS I.
- 3- PROJECTION WELDING SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF SPEC MIL-W-12332.
- 4- INTERPRETATION OF WELDING SYMBOLS SHALL BE IN ACCORDANCE WITH AWS 2.4-79.
- 5- SURFACES OF BODY RECEIVER-9348203 AND SUPPORT, TRIGGER FRAME-9348207 AND SUPPORT, BARREL-9348204 SHALL BE IN CONTACT DURING WELDING.
- 6- FOR MARKING SEE SHEET 3.
- 7- FOR DATUM TARGET AREAS SEE SHEETS 3 AND 4.
- 8- PROTECTIVE FINISH-- FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
- 9- POSITIONAL TOLERANCE APPLIES WITHIN AREA "X". SEE SHEET 4.
- 10- THE 7 MM DIA HOLES IN THE BLOCK, REAR-9348211, ARE CONSTRUCTION HOLES USED TO POSITION THE BLOCK FOR WELDING. FOR FINAL LOCATION AND HOLE SIZES, SEE SHEET 3.

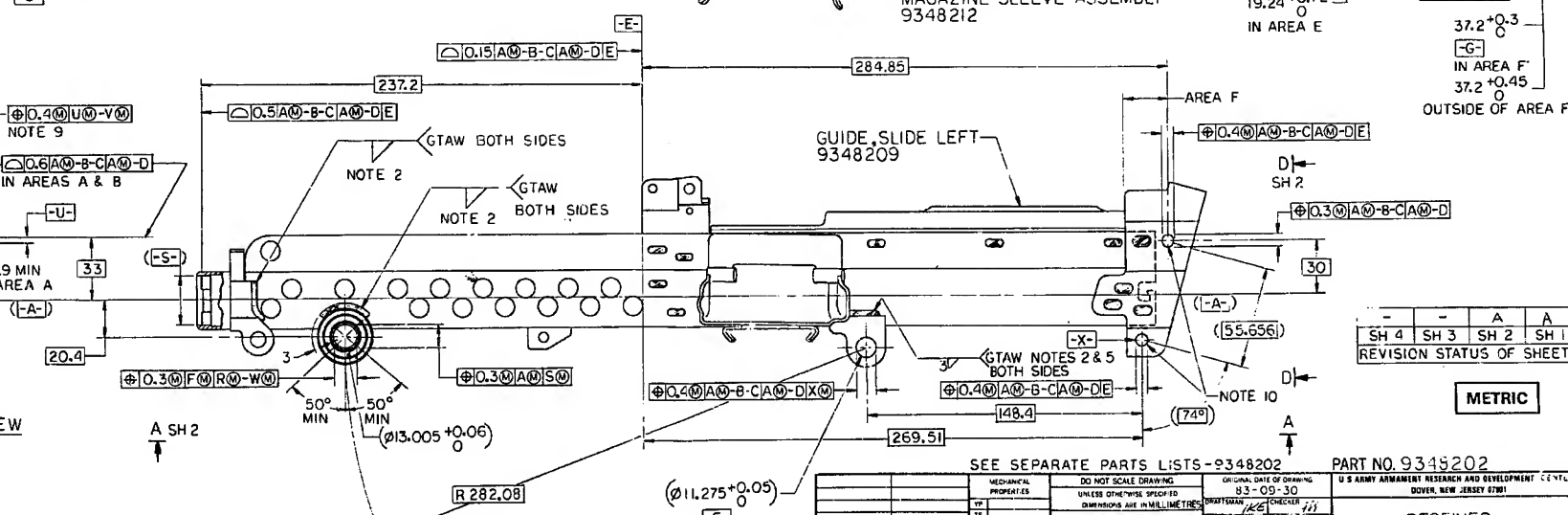
REVISIONS			
S/N	DESCRIPTION	DATE	APPROV
-	PRODUCTION RELEASE ERR W352507	830930	119 Gnd
A	NORW552548 860106	860715	FL



PARTIAL SECTION G-G



SIMPLIFIED VIEW



-	-	A	A
SH 4	SH 3	SH 2	SH 1
REVISION STATUS OF SHEET			

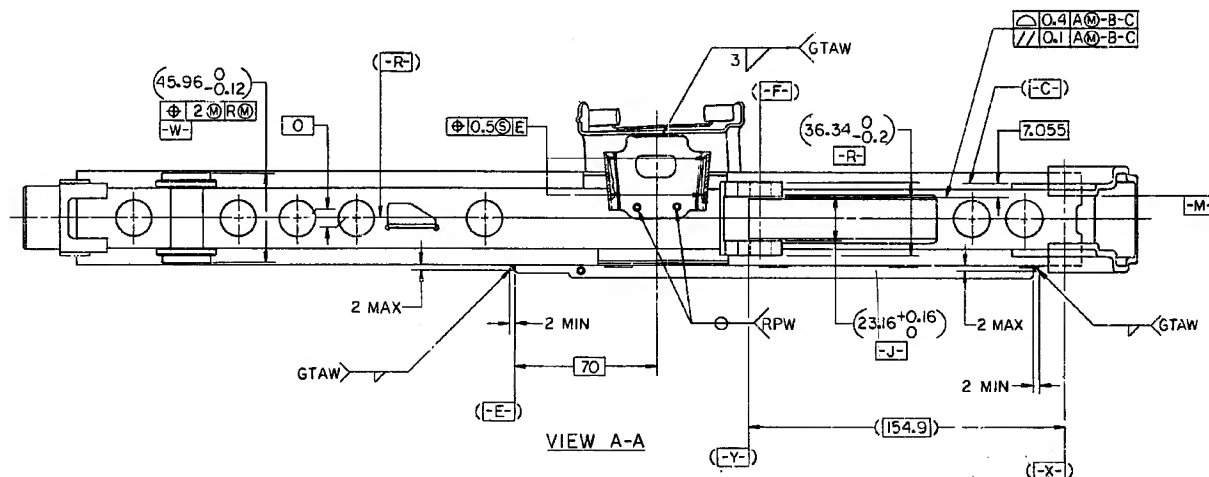
METRIC

SEE SEPARATE PARTS LISTS-9348202

PART NO. 9345202

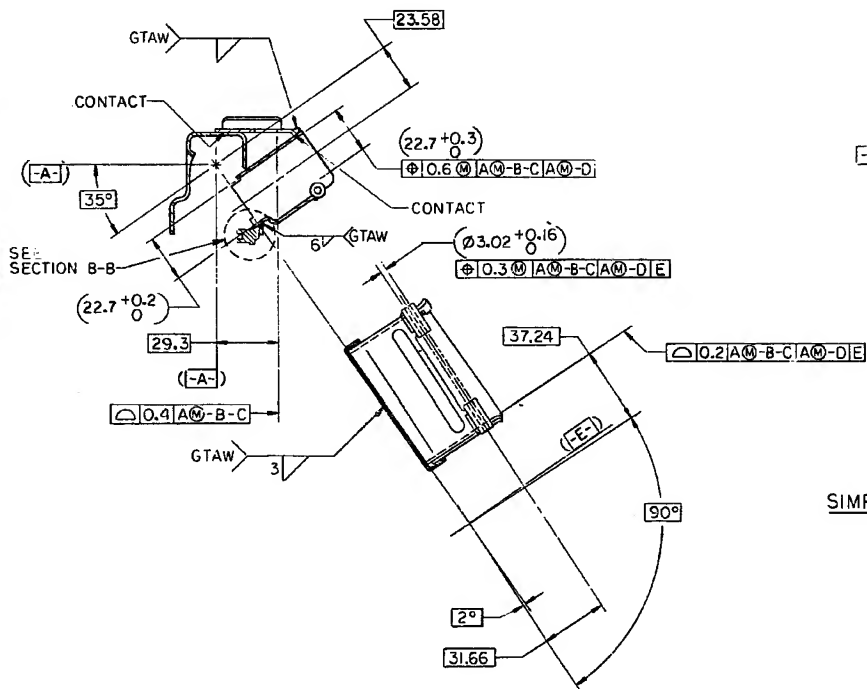
9348201		MG, M29		MEAT ASST		USED ON		APPLICATION	
9348202		MG, M29		MEAT ASST		USED ON		APPLICATION	

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
-	PRODUCTION RELEASE ERR W352507	830930	W
A	NORW552548 B6 0106	860716	W

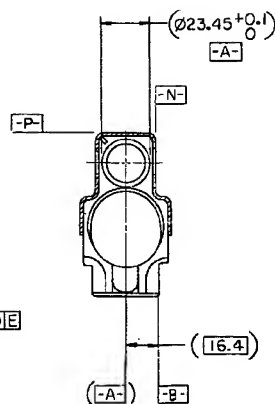


GTAW
V2.5X6
GUIDE SLIDE LEFT
9348209

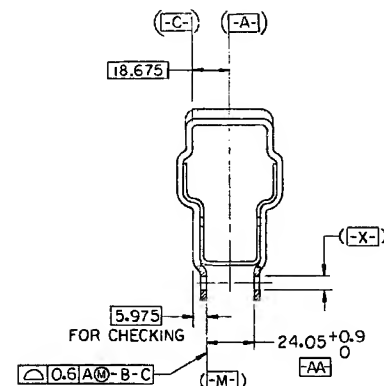
SECTION B-B



SIMPLIFIED SECTION B-B



SIMPLIFIED SECTION C-C



SIMPLIFIED VIEW D-D

METRIC

PART NO. 9348202

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

RECEIVER

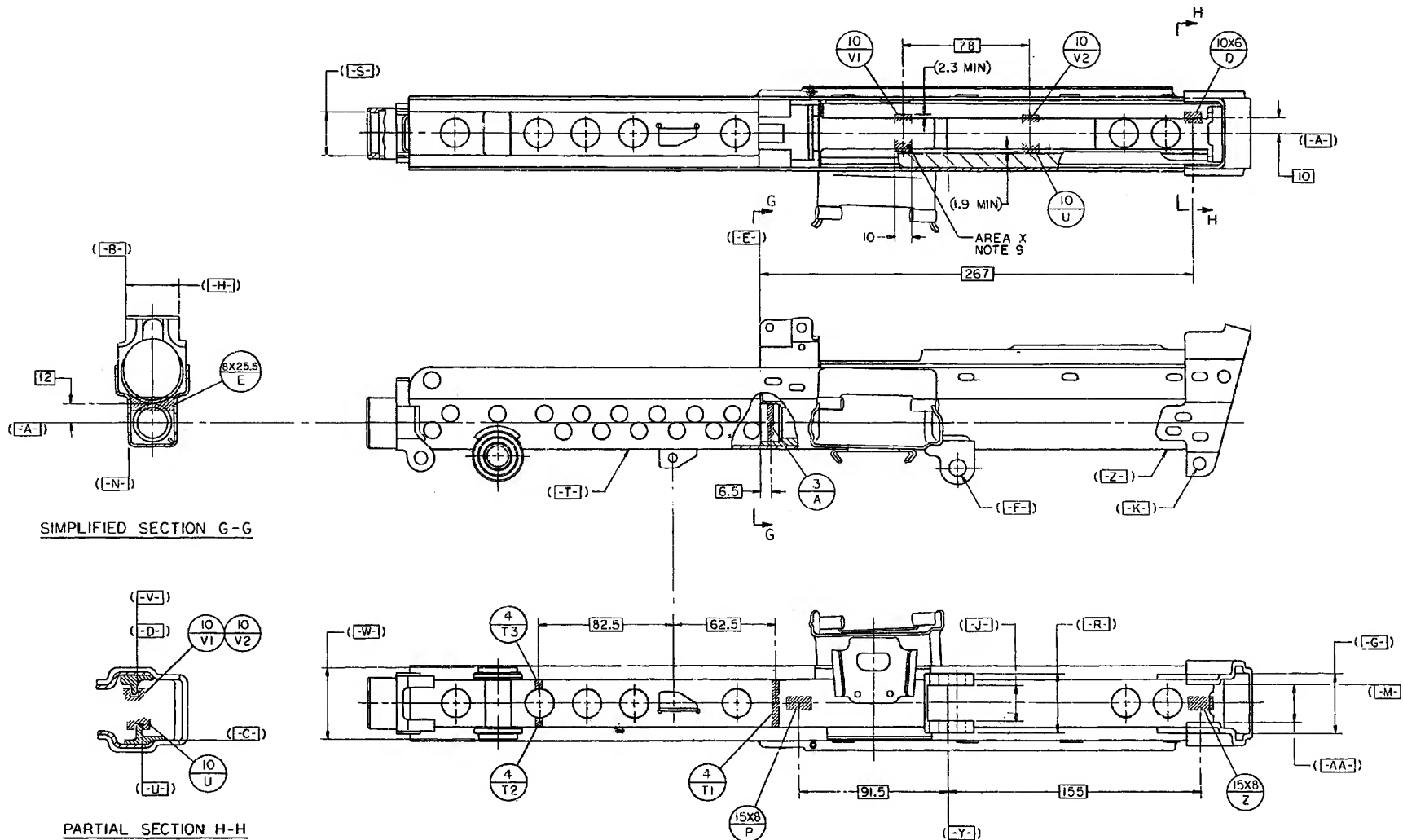
FSC NO. 9348202

SCALE 1/1 UNIT WT SHEET 2

3612101013 REV C9/13-08-83

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS		ORIGINAL DATE OF DRAWING 83-09-30	
TP		FRACCTIONS -	ANGLES -	ENGR	CHECKER
TS		THIRD ANGLE PROJECTION		ENGR	CHECKER
EL				ENGR	CHECKER
PS				ENGR	CHECKER
SH				ENGR	CHECKER
RH				ENGR	CHECKER
APPLICATION					

SYN	DESCRIPTION	DATE	APPROVAL
---	PRODUCTION RELEASE ERR W552507	830930	10/1



SIMPLIFIED SECTION G-G

PARTIAL SECTION H-H

METRIC

PART NO. 9348202

U S ARMY ARMAMENTS RESEARCH AND DEVELOPMENT CENTER
BOYD, NEW JERSEY 07001

RECEIVER
(DATUM TARGET AREAS)

SIZE F FSCM NO. 19200 9348202

SCALE 1/1 UNIT MM SHEET 1-1

3612101013 REV 09/10-05-83

MECHANICAL PROPERTIES	DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING	DATE OF REVISION
TP	UNLESS OTHERWISE SPECIFIED	83-09-30	83-09-30
TS	UNLESS OTHERWISE SPECIFIED		
EL	UNLESS OTHERWISE SPECIFIED		
RA	UNLESS OTHERWISE SPECIFIED		
SH	UNLESS OTHERWISE SPECIFIED		
AN	UNLESS OTHERWISE SPECIFIED		
APPLICATION	THIRD ANGLE PROJECTION		

QUALITY ASSURANCE PROVISION (QAP)

(DARCOM - R 702 - 10)

1. COMMAND AGENCY

U.S. ARMY ARMAMENT R, D & E CENTER
PICATINNY ARSENAL, NJ 07806 - 50002. THESE QAPS FORM PART OF DRAWING / SPECIFICATION
INSPECTION SHALL BE CONDUCTED AS SPECIFIED HEREIN AND IN ACCORDANCE WITH REFERENCED DOCUMENTS.

9348202

AS SPECIFIED IN THE CONTRACT.

UNLESS OTHERWISE SPECIFIED HEREIN OR IN THE CONTRACT, THE PROVISION OF MIL - W -
63150 SHALL APPLY AND ARE MADE A PART OF THIS DETAIL QAP.

PART I LIST OF APPLICABLE DOCUMENTS

LIST OF DRAWINGS

NUMBER NOMENCLATURE

9348202	Receiver	(Inspection Position P)
9348203	Body, Receiver	(Inspection Position A)
9348204	Support, Barrel	(Inspection Position B)
9348205	Support, Gas Cylinder	(Investment Cast)
		(Inspection Position C)
9348206	Bushing, Front	(Inspection Position D)
9348207	Support, Trigger Frame	(Inspection Position E)
9348213	Body, Magazine Sleeve	(Inspection Position K)
9348214	Bushing, Magazine Sleeve	(Inspection Position L)
9348215	Support, Feed Box	(Inspection Position N)
9348208	Guide, Cocking Handle	(Inspection Position F)
9348209	Guide, Slide, Left	(Inspection Position G)
9348210	Guide, Slide, Right	(Inspection Position H)
9348211	Block, Rear	(Inspection Position J)
9348212	Sleeve Assembly, Magazine	(Inspection Position M)

DISTRIBUTION STATEMENT A, UNLIMITED

REVISIONS

4.RELEASE NUMBER	G1S2002R1	G5S2009	L7S4181											
5. DATE	921215	970516	980630											
4.RELEASE NUMBER														
5. DATE														
REVISION STATUS OF SHEETS	6. REVISION	F	F	F	F	F	F	F	F	F	F	F	F	F
	7. SHEET	1	2	3	4	5	6	7	8	9	10	11	12	13
	6. REVISION													
	7. SHEET													

8. QAP FOR:

RECEIVER : M249 M.G.

CAGE CODE
19200

9. SUBMITTED BY:

ARDEC - SMCAR - QAF - S (D) *William D. Brown*

10. QAP NO.

9348202

11. DATE

830930

13. RELEASE NO

W3S2507

14. PAGE NO.

1

15. NO OF PAGES

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LIST OF STANDARDS

NUMBER

NOMENCLATURE

MIL-STD-105
Sampling Procedures and Tables for Inspection by Attributes.

MIL-STD-1261
Welding Procedures for Construction Steels

MIL-STD-2175
Casting Classification and Inspection of

LIST OF SPECIFICATIONS

NUMBER

NOMENCLATURE

QQ-C-320
Chromium Plating (Electrodeposited)

MIL-L-3150
Lubricating Oil, Preservative, Medium

MIL-C-16173
Corrosion Preventative Compound, Solvent Cutback, Cold-Applcation

DOD-P-16232
Phosphate coating, heavy, manganese or zinc base (for ferrous metals)

MIL-W-63150
Weapons and Support Materiel, Standard Quality Assurance Provisions for

DOD-P-63477/8-99P
Pin, Spring

LIST OF PUBLICATIONS

NUMBER

NOMENCLATURE

ASTM E 18
Standard Methods of Test for Rockwell Hardness and Rockwell Superficial Hardness of Material

ASTM B 117
Standard Method of Salt Spray (Fog) Testing

ASTM-E-1444
Standard Practice For Magnetic Particle Examination

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PART II QUALITY PROVISIONS

1. Responsibility for Inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specifications where such inspections are deemed necessary to assure supplies and service conform to prescribed requirements.

2. First Article Inspection.

2.1 Unless otherwise specified, a first article sampling consisting of five (5) items shall be submitted for inspection and approval in accordance with the terms of the contract. As determined by the Government, the sample items may be subjected to any or all of the examinations and tests specified in this QAP and be inspected for compliance with any of the requirements.

2.2 Rejection. If any sample item fails to comply with any of the applicable requirements, the first article sample shall be rejected. The Government reserves the right to terminate inspection upon any failure to comply with any of the requirements.

3. Quality Conformance Inspection

3.1 Quality Conformance Inspection shall consist of inspection of all characteristics contained in Part III "Inspection Requirements" and Part IV "Certification Provisions" of this QAP.

3.1.1 All other quality characteristics not specifically listed herein are subject to inspection under the contractor's quality or inspection system.

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PART III INSPECTION REQUIREMENTS

TABLE I CLASSIFICATION OF QUALITY CONFORMANCE CHARACTERISTICS

100% examination shall be performed for critical characteristics unless otherwise stated. Examination for major and minor characteristics shall be performed in accordance with the classification of quality conformance characteristics contained herein. Inspection Level II shall be used and individual AQL's applied in accordance with MIL-STD-105.

<u>CLASS</u>	<u>CHARACTERISTICS</u>	<u>ZONE</u>	<u>AQL</u>	<u>INSPECTION METHOD</u>
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INSPECTION POSITION A: BODY, RECEIVER - DWG - 9348203

CRITICAL: NONE

MAJOR:

101	Profile (0.4) of 37.94, 45 Degree	C-6	Sht.4 0.65	SMTE
102	Inside Width 26.75 , in area "X"	D-7	Sht.1 0.65	SMTE

MINOR:

201	Profile (0.3) of 68.25	B-4	Sht.3 1.5	SMTE
202	Profile (0.4) of 11.10	B-3	Sht.3 1.5	SMTE
203	Profile (0.4) of 239.15	B-3	Sht.3 1.5	SMTE
204	Profile (0.2) of 72.65	C-4	Sht.3 1.5	SMTE
205	Location (11.8 and 4.5) of Edge, Magazine Cutout	B-4, C-4	Sht.4 1.5	SMTE
206	Position (0.3) of 42.75	D-3	Sht.3 1.5	SMTE
207	Profile (0.4) of 249.3	F-8	Sht.3 1.5	SMTE
208	Profile (0.2) of 97.5	F-6, F-7	Sht.3 1.5	SMTE
209	All Markings Present and Proper		1.5	VISUAL
210	Profile (0.3) of 15.1	C-3	Sht.4 1.5	SMTE

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211	Profile (0.3) of 7.925, in Area "Z" 2 Places	B-7	Sht.1	1.5	SMTE
212	Profile (0.2) Inside Area "Y", 2 Places	A-6, A-7	Sht.1	1.5	SMTE
213	Profile (0.43) of 48.185, 2 Places	C-7, C-8	Sht.1	1.5	SMTE
214	Thickness (1.75) of Receiver in Area W	F-7 NOTE 2	Sht.2	1.5	SMTE
215	Profile (0.2) of 36.96, 2 Places	C-7	Sht.1	1.5	SMTE
216	Width 16.0	D-5	Sht.1	1.5	SMTE
217	Length 99.0	B-2, B-3	Sht.1	1.5	SMTE
218	Profile (0.2) of 8.3	C-4, C-5	Sht.1	1.5	SMTE
219	Position (0.1) of 23.9 Width	C-2, C-3	Sht.1	1.5	SMTE
220	Straightness (0.12) , In Area U & V	C-8	Sht.2	1.5	SMTE
221	Length 20.00	E-1, E-3	Sht.1		
222	Position (0.2) of Diameter 6.2 , (8.5)	C-3	Sht.1	1.5	SMTE
223	Length 24.0	C-5	Sht.1	1.5	SMTE
224	Position (0.1) of 14.30 Width	D-4	Sht.1	1.5	SMTE
225	Height of 10.0	B-1	Sht.1	1.5	SMTE
226	Height of 5.5	C-1	Sht.2	1.5	SMTE
227	Width 6.0	C-2	Sht.2	1.5	SMTE
228	Depth of 2.55	B-2, B-3	Sht.2	1.5	SMTE
229	Workmanship (see MIL-V-63150)	C-1	Sht.1	1.5	SMTE
				2.5	VISUAL

INSPECTION POSITION B: SUPPORT, BARREL - DWG - 9348204

CRITICAL: NONE

MAJOR:

101	Diameter (23.50) of Gas Cylinder Hole	D-8	Sht.2	0.65	SMTE
102	Position of Gas Cylinder Hole	D-8	Sht.2	0.65	SMTE
103	Profile (0.2) of Radius 17.2	D-1	Sht.1	0.65	SMTE
104	Width (20.20)	B-2/3	Sht.1	0.65	SMTE
105	Position of 20.20 Width	B-2/3	Sht.1	0.65	SMTE
106	Diameter 5.035 of Barrel Latch Pivot Hole	D-5	Sht.1	0.65	SMTE
107	Position of 5.035 (5.95 & 45.85)	D-5, C-5,	Sht.1	0.65	SMTE
108	Length 26.05 , in Area "Z"	D-6	Sht.2	0.65	SMTE
109	Perpendicularity of Datum -C-	B-5	Sht.1	0.65	SMTE
110	Diameter 38.80 of Barrel Hole	F-8	Sht.2	0.65	SMTE
111	Position of Barrel Hole Diameter	F-8	Sht.2	0.65	SMTE

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MINOR:

201	Width 20.00	D-7	Sht.1	1.5	SMTE
202	Position of 20.0 Width	D-7	Sht.1	1.5	SMTE
203	Profile (0.4) of 25.25	B-3	Sht.2	1.5	SMTE
204	Profile (0.24) of 76.8	B-4	Sht.1	1.5	SMTE
205	Profile (0.23) of 33.0	C-2	Sht.2	1.5	SMTE
206	Width 26.45	B-5	Sht.2	1.5	SMTE
207	Diameter 3.15 of Pin Hole	C-1	Sht.1	1.5	SMTE
208	Position of 3.15 Diameter Pin Hole	C-1	Sht.1	1.5	SMTE
209	Profile (0.43) of 78.375	C-4	Sht.2	1.5	SMTE
210	Profile (0.23) of 31.5 , 2 Places	B-6	Sht.2	1.5	SMTE
211	Workmanship (see MIL-W-63150)			2.5	VISUAL

INSPECTION POSITION C: SUPPORT, GAS CYLINDER - DWG -9348205

CRITICAL: NONE

MAJOR:

101	Diameter 27.10 of Gas Cylinder Hole	D-4	Sht.2	0.65	SMTE
102	Position of 27.10 Diameter	D-4	Sht.2	0.65	SMTE
103	Outside Diameter 31.60 of Gas Cylinder Hole	E-6	Sht.1	0.65	SMTE

MINOR:

201	Profile (0.2) of 7.3	D-6	Sht.1	1.5	SMTE
202	Position of 31.60 , Outside Diameter of Gas Cylinder	E-6	Sht.1	1.5	SMTE
203	Min Wall Thickness (1.46) , in Area "Y"	E-4	Sht.2	1.5	SMTE
204	Width 3.93	E-4	Sht.2	1.5	SMTE
205	Length 17.78 from -D-	F-4	Sht.2	1.5	SMTE
206	Diameter 8.04 of Retaining Pin Hole	D-2	Sht.2	1.5	SMTE
207	Position of 8.04 Diameter, Retaining Pin Hole	D-2	Sht.2	1.5	SMTE
208	Width 24.10 of Flats	B-7	Sht.1	1.5	SMTE
209	Position of 24.10 Flats	B-7	Sht.1	1.5	SMTE
210	Width 33.57	B-7	Sht.1	1.5	SMTE
211	Surface Roughness	F-6	Sht.1	1.5	SMTE
212	Workmanship			2.5	VISUAL

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INSPECTION POSITION D: BUSHING, FRONT - DWG 9348206

CRITICAL: NONE

MAJOR:

101	Diameter 13.035	C-1	0.65	SMTE
102	Diameter 23.88 , 2 Places	C-3	0.65	SMTE

MINOR:

201	Diameter 16.0	D-3	1.5	SMTE
202	Diameter 29.98	C-4	1.5	SMTE
203	Length 45.90	B-3	1.5	SMTE
204	Surface Roughness	C-1	1.5	SMTE
205	Workmanship (See MIL-W-63150)		2.5	VISUAL

INSPECTION POSITION E: SUPPORT, TRIGGER FRAME - DWG - 9348207

CRITICAL: NONE

MAJOR:

101	Diameter 11.3 of Holes , 2 Places	B-2	0.65	SMTE
102	Position of Holes , 2 Places	B-2	0.65	SMTE
103	Width 23.24 between Legs	B-8	0.65	SMTE

MINOR:

201	Thickness 3.93 of Cross Member	B-3	1.5	SMTE
202	Length 30.0	C-3	1.5	SMTE
203	Width 36.32	B-7	1.5	SMTE
204	Workmanship (See MIL-W-63150)		2.5	VISUAL

INSPECTION POSITION F: GUIDE, COCKING HANDLE - DWG - 9348208

CRITICAL: NONE

MAJOR: NONE

MINOR:

201	Diameter, (3.188) Pin Holes 2 Holes	E-6	Sht.1	1.5	SMTE
202	Position (0.07) of Pin Hole	E-6	Sht.1	1.5	SMTE
203	Profile (0.2) of 3.5	E-3	Sht.2	1.5	SMTE
204	Width 13.5	F-6	Sht.2	1.5	SMTE
205	Position (0.24) of 13.5 Width	F-6	Sht.2	1.5	9350154
206	Width 2.1	E-5	Sht.2	1.5	SMTE
207	Width 9.0	F-4	Sht.2	1.5	SMTE
208	Thickness 8.4 , 2 Places	D-3	Sht.2	1.5	SMTE
209	Surface Roughness, 1.6 , 2 Places	E-5	Sht.2	1.5	SMTE
210	Workmanship (See MIL-W-63150)			2.5	VISUAL

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INSPECTION POSITION G: GUIDE, SLIDE, LEFT - DWG - 9348209

CRITICAL: NONE

MAJOR:

101	Profile (0.24) of 2.98	C-5,	C-6	Sht.2	0.65	SMTE
102	Chromium Plating Thickness (0.045) in area specified	Note 7A		Sht.1	0.65	SMTE
103	Diameter 5.025		C-2	Sht.2	0.65	SMTE
104	Position of 5.025 Diameter		C-2	Sht.2	0.65	SMTE
105	Profile (0.16) of 13.55		B-3	Sht.2	0.65	SMTE
106	Profile (0.2) of 1.55		D-4	Sht.2	0.65	SMTE
107	Profile (0.22) of 8.53		B-6	Sht.1	0.65	SMTE

MINOR:

201	Profile (0.26) of 7.28		C-6	Sht.2	1.5	SMTE
202	Profile (0.2) of 11.51	B-6,	B-7	Sht.2	1.5	SMTE
203	Width 3.157		C-6	Sht.2	1.5	SMTE
204	Depth 8.52 of 5.025 Diameter		B-3	Sht.2	1.5	SMTE
205	Width 1.36 of Spring Slot		E-4	Sht.2	1.5	SMTE
206	Profile (0.24) of 16.58		E-4	Sht.2	1.5	SMTE
207	Profile (0.16) of 6.64		F-5	Sht.2	1.5	SMTE
208	Profile (0.3) of 237.6		D-3	Sht.1	1.5	SMTE
209	Profile 0.25 of Datum -B- (Unrestrained)		E-6	Sht.1	1.5	SMTE
210	Profile 0.25 of Datum -A- (Unrestrained)		C-6	Sht.1	1.5	SMTE
211	Workmanship (See MIL-W-63150)				2.5	VISUAL

INSPECTION POSITION H: GUIDE, SLIDE, RIGHT - DWG - 9348210

CRITICAL: NONE

MAJOR:

101	Profile (0.22) of 3.01		B-8	Sht.1	0.65	SMTE
102	Distance 8.53		E-5	Sht.1	0.65	SMTE
103	Chromium Plating Thickness (0.035)	Note 6A		Sht.1	0.65	SMTE

MINOR:

201	Profile (0.22) of 11.5		C-8	Sht.1	1.5	SMTE
202	Profile (0.36) of 11.0		C-8	Sht.1	1.5	SMTE
203	Profile (0.3) of 237.6		E-3	Sht.1	1.5	SMTE
204	Diameter 3.1 of Hinge Hole		C-1	Sht.1	1.5	SMTE
205	Position of 3.1 Diameter		C-1	Sht.1	1.5	SMTE
206	Profile (0.45) of 124.5		C-4	Sht.1	1.5	SMTE
207	Profile 0.25 of Datum -B- (Unrestrained)		D-3	Sht.1	1.5	SMTE
208	Profile 0.25 of Datum -A- (Unrestrained)		F-3	Sht.1	1.5	SMTE
209	Workmanship (See MIL-W-63150)				2.5	VISUAL

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INSPECTION POSITION J: BLOCK, REAR - DWG - 9348211

CRITICAL: NONE

MAJOR:

101	Diameter 6.35 of Weld Holes , 4 Holes	A-5	Sht.1	0.65	SMTE
102	Position of 6.35 Diameter Weld Holes, 4 Holes	A-5	Sht.1	0.65	SMTE
103	Diameter 6.35 of Weld Holes , 4 Holes	A-7	Sht.1	0.65	SMTE
104	Position of 6.35 Diameter , Weld Holes 4 Holes	A-7	Sht.1	0.65	SMTE
105	Profile (0.2) of 7.925	E-4	Sht.1	0.65	SMTE
106	Profile (0.2) of 7.925,	C-5	Sht.1	0.65	SMTE
107	Width 37.35 , Inside Area "Z"	E-4	Sht.1	0.65	SMTE
108	Profile (0.08) of 1.1 , 3.07 , 12 Degrees , Both Sides	D-3,	F-4	Sht.2	0.65 SMTE

MINOR:

201	Distance 3.95 of Recess for Cover Latches, Both Sides	C-4,	E-3	Sht.2	1.5 SMTE
202	Depth 2.20 of Recess for Cover Latches, Both Sides	C-4,	E-4	Sht.2	1.5 SMTE
203	Thickness 2.97 of Legs	Note 2 Sht.1 1.5 SMTE			
204	Profile (0.1) of 21.25 , 16 Degrees	E-8 Sht.1 1.5 SMTE			
205	Workmanship (See MIL-W-63150)	2.5 VISUAL			

INSPECTION POSITION K: BODY, MAGAZINE SLEEVE - DWG - 9348213

CRITICAL: NONE

MAJOR:

101	Height 22.8 , Magazine Opening	E-5 Sht.1 0.65 SMTE			
102	Length 64.76 , Magazine Opening	E-4, E-5 Sht.1 0.65 SMTE			
103	Length 60.6	F-4, F-5 Sht.1 0.65 SMTE			

MINOR:

201	Length 8.0 , Cutout for Bushing Both Sides	D-4,	D-6	Sht.1	1.5 SMTE
202	Profile (0.44) of 27.6	D-7,	D-8	Sht.2	1.5 SMTE
203	Height 4.7 of Offset Leg	B-4 Sht.1 1.5 SMTE			
204	Workmanship (See MIL-W-63150)	2.5 VISUAL			

INSPECTION POSITION L: BUSHING, MAGAZINE SLEEVE - DWG 9348214

CRITICAL: NONE

MAJOR: NONE

MINOR:

201	Outside Diameter 7.70	C-2	1.5	SMTE
202	Inside Diameter 3.10	B-2	1.5	SMTE
203	Length 15.75	B-3	1.5	SMTE
204	Workmanship (See MIL-W-63150)		2.5	VISUAL

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INSPECTION POSITION M: MAGAZINE SLEEVE ASSEMBLY - DWG - 9348212

CRITICAL: NONE

MAJOR:

All Components Present, Correct,
and Properly Assembled

0.65 VISUAL

MINOR:

201	Height 22.95 , 2 Places	B-6	1.5	SMTE
202	Location 12.75	C-5	1.5	SMTE
203	Width 39.40 Between Bushings	C-4, C-5	1.5	SMTE
204	Profile (0.45) to Datums	D-4	1.5	SMTE
205	Position of 3.1 Diameter	C-6	1.5	SMTE
206	Workmanship (See MIL-W-63150)		2.5	VISUAL

INSPECTION POSITION N: SUPPORT, FEED BOX - DWG - 9348215

CRITICAL: NONE

MAJOR: NONE

MINOR:

201	Profile (0.65) of 5.17 Height	D-3 Sht.1	1.5	SMTE
202	Angularity (0.1) of 4.0 , 45 Degrees 2 Places	B-3, D-3 Sht.2	1.5	SMTE
203	Length 7.95 of Legs , 2 Places	C-2, E-4 Sht.2	1.5	SMTE
204	Thickness 1.75	NOTE 2	1.5	SMTE
205	Workmanship (See MIL-W-63150)		2.5	VISUAL

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INSPECTION POSITION P: RECEIVER - DWG - 9348202

CRITICAL: NONE

MAJOR:

101	Profile (0.6) of 237.2	B-7	Sht 1	0.65	12923173
102	Width (19.6) Between Rails	E-2	Sht 1	0.65	9350156 / SMTE
103	Position (1.0) of Datum -J-, 18.39 , 27	B-7	Sht 1	0.65	12923173 / 12923088
104	Profile (0.46) of 28.225 in Area "S"	F-1	Sht 1	0.65	12923102
105	Position (0.4) of 121.11 , (Ø 11.3)	B-4	Sht 1	0.65	12923102
106	Functional Condition of Holes to Backface of Rear Block	NOTE 9		0.65	12923101
107	Diameter (8.050) thru, Lower Holes	D-8	Sht 3	0.65	SMTE
108	Position (Ø 0.4 , Ø 0) of Diameter 8.050 , Lower Holes	D-8	Sht 3	0.65	12923102 / SMTE
109	Diameter (8.050) thru, Upper Holes	E-8	Sht 3	0.65	SMTE
110	Profile (0.4) of 3.0 , Entire Length	B-8	Sht 3	0.65	12923166 / 9350156
111	Profile (0.5) of Datum -A-, in Area "H"	B-5	Sht 3	0.65	12923166 / 9350156
112	Position (0.3) of Diameter 3.005 , 40.84, in Area "Z"	C-4	Sht 3	0.65	12923102
113	Profile (0.5) of 12.35 , in Area "Y"	D-6	Sht 4	0.65	12923175
114	Profile (0.2) of 26.05	F-3	Sht 4	0.65	12923166
115	Profile (0.4) of 261.35 , 2 places	D-2	Sht 1	0.65	12923102
116	Functional Condition Between Guides	Note 8		0.55	9350156
117	Width 22.55 Min, in Area "X" of (22.80)	B-4	Sht 3	0.65	12923171
119	Profile (0.6) of 16.962	B-5	Sht 3	0.65	SMTE
119	Profile (0.4) of 41.91, in Area "L"	D-5	Sht 2	0.65	SMTE
120	Salt Spray				See 505
121	Coating Weight				See 506
123	Supplemental Oil				See 507
124	All Components Present & Properly Assembled			0.65	VISUAL

MINOR:

201	Position (0.3) of Diameter 13.035, R282.08	B-5	Sht 1	1.5	9350155
202	Diameter (6.035)	D-4	Sht 1	1.5	SMTE
203	Position (0.16) of Diameter 6.035, 26	C-5	Sht 1	1.5	12923166
204	Profile (0.6) of 26.33, in Area "M" 2 Places	D-1	Sht 1	1.5	12923102
205	Profile (0.6) of 22.0	E-5	Sht 1	1.5	12923102
206	Width (24.40)	D-8	Sht 2	1.5	SMTE
207	Position (0.17) of Datum -L-	B-5	Sht 2	1.5	12923170
208	Position (Ø 0.08) of Diameter 8.050 , Upper Holes	E-8	Sht 3	1.5	12923168 / SMTE
209	Profile (0.6) of 18.0 , in Area "J"	B-3	Sht 2	1.5	12923102
210	Profile (0.4) of 37.66 , in Area "K"	D-5	Sht 3	1.5	12923102
211	Angularly (0.2) of 37.66 in Area "K"	D-5	Sht 3	1.5	SMTE
212	Profile (0.27) of 0.06 , in Area "N"	D-5	Sht 1	1.5	12923172
213	Width (32.75)	F-4	Sht 4	1.5	SMTE
214	Profile (0.6) of Datum -A-, Outside Area "H"	B-5	Sht 3	1.5	12923166
215	Protective Finish			1.5	VISUAL
216	Workmanship (See MIL-W-63150)			2.5	VISUAL

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		C , 921215	D , 950614	E , 970516	F , 980630
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TABLE II SPECIAL SAMPLING INSPECTION

Dimensional control of cast parts. In place of the normal sampling associated with the Classification of Defects, and with the approval of the Contracting Officer, a sample of at least ten (10) parts (as cast) from each cavity shall be dimensionally inspected to qualify a new or reworked cavity for use in production or as a control of the cavity during production. In addition, a random sample of five (5) parts from each cavity after production of 5,000 consecutive parts from each cavity shall be selected for dimensional inspection as a control of the cavity during production. Individual cavity identification shall be provided.

If any defective parts are found during qualification of the cavity, the cavity producing the defective part will not be used in production. If any defective parts are found when inspection is performed for control of the cavity, the cavity producing the defective part shall be removed from production. Further, that portion of production since the last control check shall be returned to the contractor for corrective action.

All cavities formerly removed from production because of some fault may, after reworking, be returned to production providing they pass the qualification test specified above. The contractor may request a change of inspection frequency providing he presents objective evidence to substantiate the request to the Contracting Officer.

NOTE: This casting inspection does not apply to characteristics which are defined as "Critical"; characteristics which are created by machining; characteristics which are visually inspected; and characteristics for surface finish.

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PART IV CERTIFICATION PROVISIONS

Certified test reports in accordance with the provisions of MIL-W-63150 are required for the following:

<u>NUMBER</u> 401	<u>CHARACTERISTIC</u> Material	<u>TEST DATA TO COMPLY WITH</u> 9348203 9348204 9348205 9348206 9348207 9348208 9348209 9348210 9348211 9348213 9348214 9348215
402	Heat Treatment	9348204 9348205 9348209 9348210
403	Hardness	9348204 9348205 9348209 9348210
	Case Depth Hardness	9348204
404	Protective Finish	9348202
405	Magnetic Particle Inspection	9348202 / Note 6
406	Welding	9348202 and MIL-STD-1261 9348212 and MIL-STD-1261 9348213 and MIL-STD-1261
407	Investment Casting Inspection Class 2, Grade B	9348205/ MIL-STD-2175
408	Direction of Grain	9348203
409	Chromium Plating Adhesion	9348209 / QQ-C-320 9348210 / QQ-C-320
410	Pin, Spring	DOD-P-63477/8-99P/CTR

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PART V TEST METHODS AND PROCEDURES

501 Characteristics Major 101 through 113 of position '0' shall be inspected before painting.

502 The contractor shall perform the magnetic particle inspection after the product has been prepared according to MIL-I-6868.

503 HARDNESS

Five samples shall be selected from each heat treatment batch. Testing shall be in accordance with ASTM E18. Each heat treatment batch shall remain segregated until all tests are completed. If any sample fails to comply with the hardness requirements, it shall be classified as defective and the lot shall be rejected. A heat treatment batch is defined as parts that have been heat treated at the same time in the same furnace and quench bath for all phases of the heat treatment process.

504 CASE DEPTH HARDNESS

Three (3) samples shall be selected from each day's production from each carburizing furnace or salt pot used. Each sample shall be cut perpendicular to the cased surface and the cut surface shall then be prepared by grinding or rough polishing to remove the effects of the original cut. Etching will be done with a weak solution (1-10%) Nitric acid in alcohol and of sufficient time to develop a contrast in case and core structure. The depth of case shall be the total distance of penetration from the surface to the nearest point of uniform core structure as measured on a polished and etched specimen at a magnification not lower than 10 diameters. If any sample fails to comply with the specified requirements, it shall be classed defective and the lot shall be rejected.

505 SALT SPRAY TEST

Five (5) parts shall be selected from each lot. The test shall be performed as specified in DOD-P-16232 and ASTM B 117 without the supplemental oil. Test procedures and equipment shall have the prior approval of the Government. If any part shows evidence of corrosion, it shall be classified as defective and the entire lot shall be rejected.

506 COATING WEIGHT

Five (5) samples or five test panels shall be selected from each lot. The test shall be performed as specified in DOD-P-16232. Test procedures and equipment shall have the prior approval of the Government. If any sample does not meet the requirement of DOD-P-16232, it shall be classified as defective and the lot shall be rejected.

507 SUPPLEMENTAL OIL TREATMENT SALT SPRAY

The test shall be performed for first article and at least semi-monthly during production. Three test panels from each processing tank or dispenser shall be prepared and tested in accordance with MIL-L-3150 or MIL-C-16173 (as applicable) and ASTM B117 using a 5% salt solution. The test duration and accept/reject criteria shall be as specified in the applicable specification. If any test panel fails to meet the applicable requirement, all items processed since the last acceptable test shall be rejected.

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